

shp Oct 20 12:00

Work Order ID 124820

September-24-14 1:19:52 PM

124820

Page 1

Item ID: D350-600-248

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Spacepod™ Door Fwd Opening RH

Stop *NS2*

Start Date: 9/24/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/03/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: u

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-600

Rev E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-600-248 CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

Small Fab

0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per IIN D350-600

per ECU
14-509
mf
14-70-02

14-10-16

IX
DAS
26
9-89
SEP 30 2014

BT 14-10-14 x/

Work Order ID 124820

124820

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Item ID: D350-600-248 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacepod™ Door Fwd Opening RH
 Start Date: 9/24/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/03/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Packaging	0.00							
160									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-248 Location: _____ PPP Rev: _____								
								DAS 06 9-89	
									OCT 15 2014
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

14/10/16
 ME
 14-10-15

Picklist Print

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Work Order ID: 124820

124820

Parent Item: D350-600-248

D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 07.05.24 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C832R10 *AN526C832R10* Screw		Purchased	No			120	Each	167.0000	2	2		DAS 32 9-89	DAS 26 9-89
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST327				167					
				123831				67					
				m127363				100					
AN526C832R14 *AN526C832R14* Screw		Purchased	No			120	Each	307.0000	2	2		DAS 32 9-89	DAS 26 9-89
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST327				307					
				124215				307					
AN526C832R24 *AN526C832R24* screw		Purchased	No			120	Each	104.0000	4	4		DAS 32 9-89	DAS 26 9-89
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST327				104					
				118870				38					
				124255				66					
AN960JD516 *AN960JD516* Washer	NAS1149D0563J	Purchased	No			120	Each	28.0000	1	1		DAS 32 9-89	DAS 26 9-89
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				Return2014				28					
				122452				18					
				125807				10					

SEP 29 2014

14/10/2

123831

124215

118870

M128207

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Work Order ID: 124820

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Parent Item: D350-600-248

D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832 Purchased No

AN960.IND8

Washer

D2228 Manufactured No

D2228

Backing Plate

Location

Loc Qty

Loc Code

ST004

70

105984

31

73380

6

95704

33

D2464 Manufactured No

D2464

Seal(\$per foot)

Location

Loc Qty

Loc Code

ST409

602.9

110770

108.28

121946

479

83543

15.62

D3015-3 Manufactured No

D3015-3

Locknut

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

172

111465

2

117832

170

DAS
28
9-89

DAS
32
9-89

DAS
32
9-89

DAS
28
9-89

DAS
32
9-89

DAS
28
9-89

DAS
32
9-89

SEP 30 2014

DAS
28
9-89

14/10/2 (1)

117832

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Work Order ID: 124820

Parent Item: D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

124820

D350-600-248

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

D3186-4

D3186-4

Spacepod Door, RH

Manufactured No

Each

1.0000

1

1

**

DAS
32
9-89

DAS
26
9-89

25 14-10-15

Location

Loc Qty

Loc Code

FG

1

105745

1

Each

38.0000

1

1

**

DAS
32
9-89

DAS
26
9-89

105745

D3554-7

D3554-7

Ball Stud

Manufactured No

120

Each

Location

Loc Qty

Loc Code

FG

5

87039

5

ST049

33

87039

8

87571

25

Each

7.0000

1

1

**

SEP 30 2014

DAS
26
9-89

87571

D3557-1

D3557-1

Bracket

Manufactured No

120

Each

Location

Loc Qty

Loc Code

ST049

7

73384

7

Each

7.0000

1

1

**

DAS
32
9-89

DAS
26
9-89

73384

D3567-2

D3567-2

Decal

Manufactured No

120

Each

Location

Loc Qty

Loc Code

ST048

7

50375

7

DAS
32
9-89

SEP 30 2014

14/10/2

50375

05127-1 x 2 B 123193
05127-3 x 2 B 123193

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Parent Item: D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

124820

D350-600-248

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

A3235-020-935

Purchased

No

150

Each

345.0000

1 1

A3235-020-935

Washer, Countersunk

DAS
38
9-89

**

DAS
32
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST266

345

106150

145

M128403

200

106150

DAS
32
9-89

DAS
06
9-89

AN526C832R10

Purchased

No

150

Each

167.0000

8 8

AN526C832R10

Screw

DAS
38
9-89

**

Location

Loc Qty

Loc Code

ST327

167

123831

67

m127363

100

123831

DAS
32
9-89

DAS
06
9-89

AN526C832R14

Purchased

No

150

Each

307.0000

4 4

AN526C832R14

Screw

DAS
38
9-89

**

Location

Loc Qty

Loc Code

ST327

307

124215

307

124215

DAS
32
9-89

DAS
06
9-89

AN5-5A

Purchased

No

150

Each

37.0000

1 1

AN5-5A

Bolt

DAS
38
9-89

**

Location

Loc Qty

Loc Code

ST361

37

110865

37

110865

14/10/02 (1)

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Work Order ID: 124820

Parent Item: D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

124820

D350-600-248

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No
AN960.ID10 **DAS 38 9-89**
 WASHER

150 Each 11.0000

1 1
 ** M/28429 **DAS 32 9-89** **DAS 06 9-89**

Location Loc Qty Loc Code

ST335 11
 116393 11

AN960JD10L NAS1149D0332J Purchased No
AN960.ID10L **DAS 38 9-89**
 Washer

150 Each 0.0000

1 1
 ** M/28612 **DAS 32 9-89** **DAS 06 9-89**

AN960JD516 NAS1149D0563J Purchased No
AN960.ID516 **DAS 38 9-89**
 Washer

150 Each 28.0000

3 3
 ** M/28257 **DAS 32 9-89** **DAS 06 9-89**

Location Loc Qty Loc Code

Return2014 28
 122452 18
 125807 10

AN960JD8 NAS1149DN832 Purchased No
AN960.ID8 **DAS 38 9-89**
 Washer

150 Each 0.0000

12 12
 ** M/29499 **DAS 32 9-89** **DAS 06 9-89**

D2237 Manufactured No
D2237 **DAS 38 9-89**
 Striker Plate

150 Each 117.0000

1 1
 ** **DAS 32 9-89** **DAS 06 9-89**

Location Loc Qty Loc Code

ST004 70
 121380 20
 121746 50
 ST005 47
 108708 1
 112911 1
 116707 45

14/10/2011
 116707

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Work Order ID: 124820

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Parent Item: D350-600-248

D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

D3538-1
D3538-1
Hinge Bracket

DAS
38
9-89

Manufactured No

150 Each

21.0000

2 2

**

DAS
32
9-89

DAS
06
9-89

Location Loc Qty Loc Code

FG 12

105999 4

115602 1

84630 1

98281 6

ST048 7

118849 7

ST049 2

115602 1

98281 1

118849

D3547-1
D3547-1
Bracket

DAS
38
9-89

Manufactured No

150 Each

28.0000

**

DAS
32
9-89

DAS
06
9-89

Location Loc Qty Loc Code

ST049 28

106211 28

106211

D3550-1
D3550-1
Strut

DAS
38
9-89

Manufactured No

150 Each

7.0000

**

DAS
32
9-89

DAS
06
9-89

Location Loc Qty Loc Code

ST253 7

101529 2

112152 1

112154 1

83114 3

101529

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Parent Item: D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

124820

D350-600-248

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

D3552-7 Manufactured No

150 Each

16.0000

D3552-7

Door Prop

DAS 38 9-89

**

DAS 32 9-89

DAS 32 9-89

Location

Loc Qty

Loc Code

FG	2	
85044	2	
ST260	14	
106032	4	
115663	1	
118882	7	
83115	2	

118882

D3554-7 Manufactured No

150 Each

38.0000

D3554-7

Ball Stud

DAS 38 9-89

**

DAS 32 9-89

DAS 32 9-89

Location

Loc Qty

Loc Code

FG	5	
87039	5	
ST049	33	
87039	8	
87571	25	

87039

MS20426AD4-5 Purchased No

150 Each

554.0000

MS20426AD4-5

RIVET

DAS 38 9-89

**

DAS 32 9-89

DAS 32 9-89

Location

Loc Qty

Loc Code

ST313	554	
6874	70	
m125807	484	

m125807

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Work Order ID: 124820

Parent Item: D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

124820

D350-600-248

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

150

Each

3,145.000

4 4

MS21042L08

DAS

38

9-89

Nut

**

DAS

32

9-89

Location

Loc Qty

Loc Code

ST306

3145

123900

1

125445

268

m127304

99

m127410

412

m128401

1500

m128429

69

m129541

196

m130325

600

MS21042L3

Purchased

No

150

Each

2,123.000

2 2

MS21042L3

DAS

38

9-89

Nut

**

DAS

32

9-89

Location

Loc Qty

Loc Code

ST307

2123

123900

934

M127410

11

M127831

41

M128401

42

M128754

1095

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Work Order ID: 124820

Parent Item: D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

124820

D350-600-248

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

150

Each

1,135.000

MS21042L5

Nut

DAS
38
9-89

**

DAS
32
9-89

DAS
32
9-89

Location

Loc Qty

Loc Code

ST307

1135

125684

8

m127304

1

m127813

497

m128810

7

m129472

22

m130358

600

130308

MS24694-S69

Purchased

No

150

Each

43.0000

MS24694-S69

Screw

DAS
38
9-89

**

DAS
32
9-89

DAS
32
9-89

Location

Loc Qty

Loc Code

ST292

43

112492

43

MS27039-08-11

Purchased

No

150

Each

478.0000

MS27039-08-11

SCREW

DAS
38
9-89

**

DAS
32
9-89

DAS
32
9-89

Location

Loc Qty

Loc Code

ST287

478

m130358

478

MS27039-1-25

Purchased

No

150

Each

135.0000

MS27039-1-25

Screw

DAS
38
9-89

**

DAS
32
9-89

DAS
32
9-89

Location

Loc Qty

Loc Code

ST289

135

102602

35

m127432

100

102602

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Work Order ID: 124820

Parent Item: D350-600-248

Parent Item Name: Spacepod™ Door Fwd Opening RH

124820

D350-600-248

Start Date: 9/24/14

Required Date: 10/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased

No

150

Each

369.0000

2 2

NAS1515H3

Washer

DAS
38
9-89

**

14/12/02

DAS
38
9-89

Location

Loc Qty

Loc Code

FG

10

123301

10

ST273

359

m128635

123

m129521

236

DAS
32
9-89

m128635

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3.5 FORWARD OPENING SPACEPOD™ UPGRADE KIT INSTALLATION (D350-600-247/-248)

- 3.5.1 Remove the existing D3186-1/-2 *Spacepod*™ door by disconnecting the hinges.
- 3.5.2 Install the D3547-1 bracket, D3554-7 ball stud and D3550-1 strut as shown in Figure 19:
- If the four outboard fasteners on the aft D2174-041 web assembly in the *Spacepod*™ are rivets, drill out the rivets to Ø 0.172". If the four outboard fasteners on the web assembly are threaded fasteners, remove the fasteners.
 - Install the D3547-1 bracket with the D3554-7 ball stud with new fasteners and torque as shown.
 - Position the D3550-1 strut so that the pre-drilled end aligns with the mounting hole on the D3547-1 bracket and so that the other end aligns with one of the roof mounting holes at the forward web assembly as shown. If necessary, trim the end of the strut to fit. Remove the roof fasteners at this hole. Transfer drill from the roof to the strut using a Ø0.194" (drill #10).
 - Install new fasteners to connect the *Spacepod*™ roof, web assembly and strut as shown. Torque the 5/16" strut fasteners as shown. Do not torque the roof fasteners.

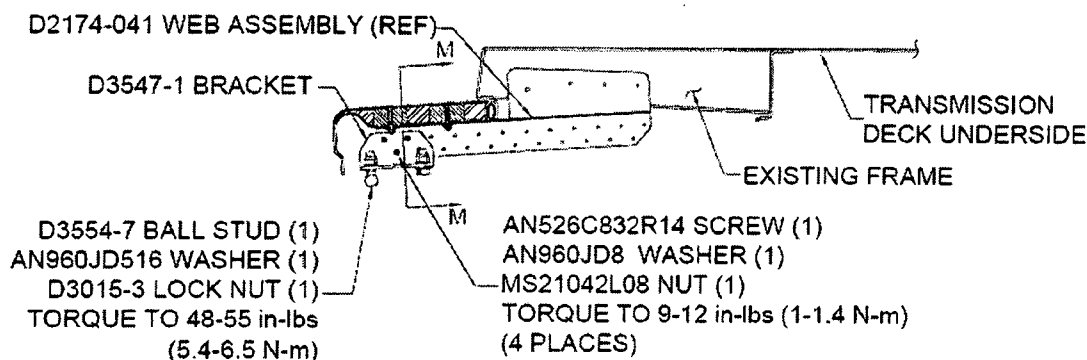
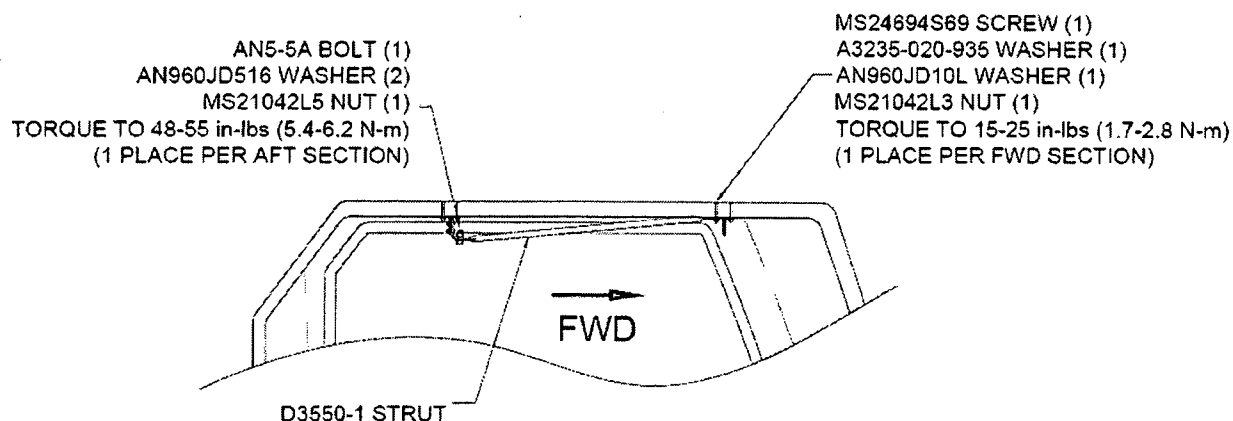


FIGURE 19 – BRACKET AND BALL STUD INSTALLATION
(LH SIDE -247 UPGRADE KIT SHOWN; RH SIDE -248 UPGRADE KIT OPPOSITE)



SECTION 'M-M' STRUT INSTALLATION

- 3.5.3 Remove the following components from the door and pod as shown in Figure 20:
- Remove the D2977/D2978 hinge brackets and D2179 hinge bracket plates from the pod. Reinstall the hardware to fill the holes in the pod. Retain the hinge bracket plates for reinstallation on the new *Spacepod*™ door. Discard the hinge brackets.

- b. Remove the D2857-1/-2 hinge brackets and the D2228 backing plates and retain for reinstallation on the new *Spacepod™* door. Discard the hardware.
- c. Remove two D2586 latches, D2621 latch plates and D2588 mounting channels and retain for reinstallation on the new *Spacepod™* door. Remove the D2012-107 clevis, D2429 spring clip assembly and D2982-041 prop arm from the latch assemblies as applicable and discard with the hardware.
- d. Remove the SL69-BS ball stud.
- e. Optional – remove the D2219 door support bracket by drilling out the rivets. Fill in the rivet holes in the pod using new rivets.

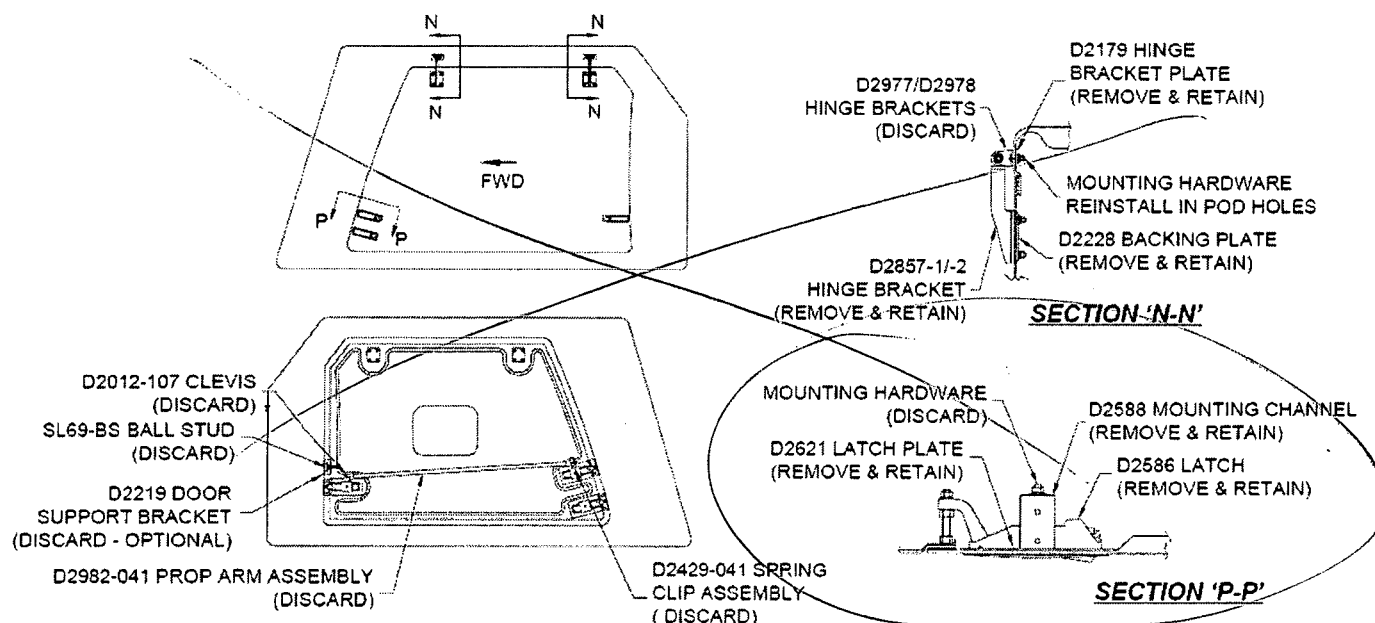


FIGURE 20 – COMPONENT REMOVAL FROM EXISTING SPACEPOD™ KIT
 (-041/-141 KIT SHOWN; -042/-142 OPPOSITE, -043/-143 KITS SIMILAR)

- 3.5.4 Reinstall the D2857-1/-2 hinge brackets and the D2228 backing plates with new hardware on the new D3186-3/-4 *Spacepod™* door as shown in Figure 21. For the LH *Spacepod™*, install the D2857-1 hinge bracket on the lower set of mounting holes and the D2857-2 hinge bracket on the upper set of mounting holes. For the RH *Spacepod™*, install the D2857-1 hinge bracket on the upper set of mounting holes and the D2857-2 hinge bracket on the lower set of mounting holes.

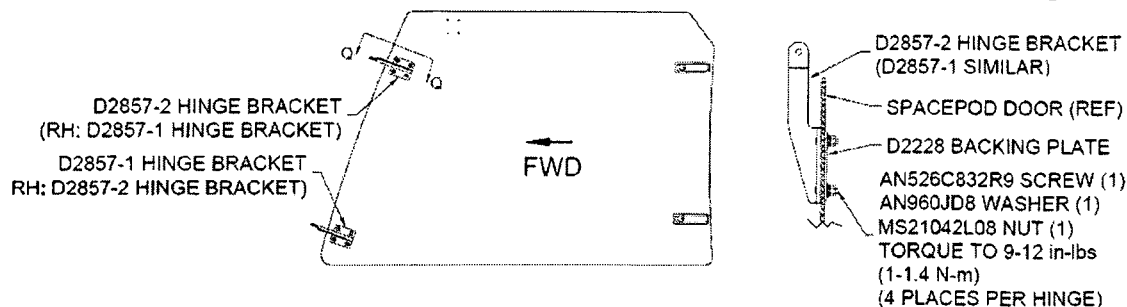
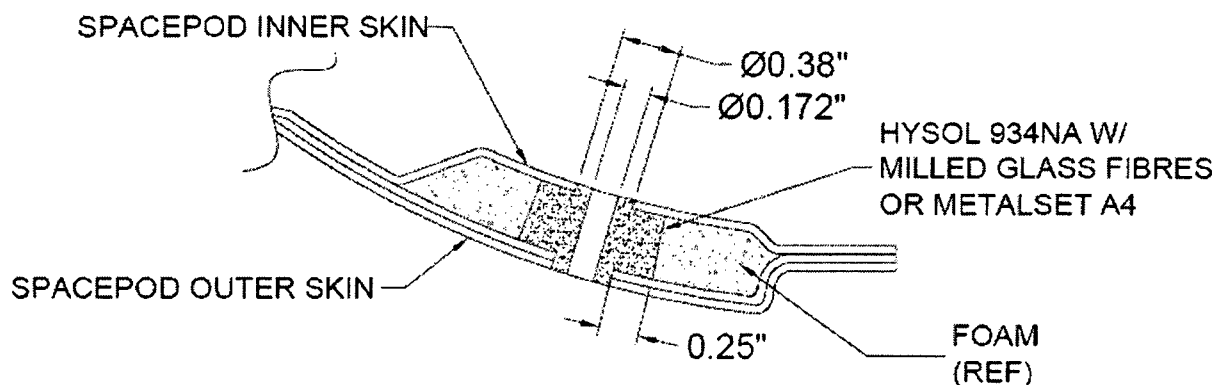
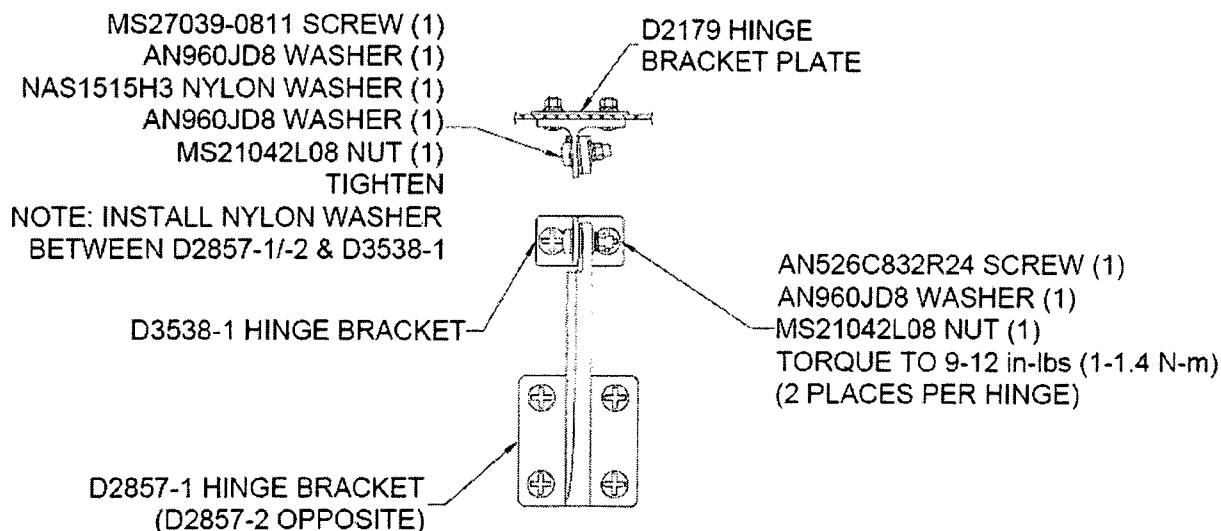


FIGURE 21. HINGE BRACKET INSTALLATION
 (-041/-141 KITS SHOWN; -043/-143 SIMILAR; -042/-142 OPPOSITE)

3.5.5 Install the D3538-1 hinge brackets on the pod as shown in Figure 22:

- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown. Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the *Spacepod™* body.
- Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 22(a).
- Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to a ratio of 10:1 or Metalset A4. Allow the material to cure.
- Reposition the *Spacepod™* door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
- Install the D3538-1 hinge brackets and *Spacepod™* door as shown in Figure 22(b).

**FIGURE 22(a) – COMPOSITE MODIFICATION****FIGURE 22(b) – HINGE BRACKET INSTALLATION**

- 3.5.6 Install the latches on the new D3186-3/-4 *Spacepod*™ door, as well as an additional striker plate on the *Spacepod*™ body. Refer to Figure 14(c).
- a. Reinstall the D2586 latches, the D2621 latch plates and the D2588 mounting channels removed earlier in the rectangular holes provided in the new *Spacepod*™ door.
 - b. Align the D2237 striker plate with the upper latch. Transfer mark the two holes and drill to Ø0.129" (drill #30). Install the striker plate using two MS20426AD4-5 rivets. Refer to the lower aft striker plate as an example.
- 3.5.7 Install the D3552-7 gas spring rod end down on the ball studs.
- 3.5.8 Adjust the latches as necessary to ensure that the door closes tightly and securely.

REFERENCE ONLY

DART AEROSPACE LTD.

DAS
38
9-89

IIN-D350-600
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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5-7	IRIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

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Revision: E
Date: 09.07.31

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REFERENCE ONLY

IIN-D350-600

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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS-KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1	1					D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E
Date: 09.07.31

ship Oct 20 12:00

Work Order ID 124820

124820

Page 1

September-24-14 1:19:52 PM

Item ID: D350-600-248

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacepod™ Door Fwd Opening RH

Start Date: 9/24/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/03/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D350-600	Rev E

100

0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D350-600-248 CHG001

0.00

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

Small Fab

0.00

120

Small Fab

Small Fab

Memo

Assemble as per IIN D350-600

0.00

2 per ECU
14-509
ms
14-10-02

MLJ 14-10-16

DAS
28
9-88

SEP 30 2014

IX

25 14-10-14 X